

Work Order ID 82953

82953

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Wednesday, April 11, 2012 3:02:35 PM

Item ID: DSK080 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2896-1 TURNING DETAIL
 Start Date: 4/11/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/19/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: *R* Date: *12-04-11* Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK080	Rev A								

100 0.00
100 MORI SEIKI CNC LATHE LARGE
 Doosan Memo
 Doosan Lathe Turn blank as per Folio FA167
and 12/04/23
SL 12/4/24

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo
 Quality Control
SL 12/4/24

120 0.00
120 QC8- Inspect parts - second check
 QC Memo
 Quality Control
SL 12-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82953

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Wednesday, April 11, 2012 3:02:35 PM

Item ID: DSK080

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D2896-1 TURNING DETAIL

Start Date: 4/11/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/19/2012 Req'd Qty: 10.00

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Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: MAT060		SL	12-04-25					
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/4/259

12-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 11, 2012 3:02:40 PM

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Work Order ID: 82953

82953

Parent Item: DSK080

DSK080

Parent Item Name: D2896-1 TURNING DETAIL

Start Date: 4/11/2012

Required Date: 4/19/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-011		Manufactured	No			100	Each	8.0000	1	10			

D6104-011

17-4 SS Roundbar 6.50"OD

**

Location

Loc Qty

Loc Code

MAT047

8

80116

8

8 OK 12/04/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82253
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.480	3.485		3.483	3.485	3.488	3.488	3.488
B	3.990	4.010		4.008	4.001	4.001	4.000	4.000
C	3.825	3.845		3.834	3.835	3.834	3.834	3.835
D	0.718	0.738		.730	.730	.730	.730	.730
E	0.090	0.110		.101	.101	.101	.101	.101
F	3.705	3.725		3.714	3.715	3.715	3.714	3.715
G	1.360	1.380		1.370	1.370	1.370	1.370	1.370
H	1.250	1.260		1.260	1.255	1.258	1.258	1.258
I	6.490	6.510		6.497	6.498	6.498	6.498	6.498
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.240	0.260		.250	.260	.260	.260	.260
L	0.107	0.127		.116	.115	.115	.115	.115
M								
N								
O								
P								

Measured by: SJA / Date: 12/4/24

Audited by: JL Date: 12-04-25

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82253
Description: Turning Detail for D2896-1		Part Number:	DSK080
Inspection Dwg: DSK080	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
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Lathe Section								
A	3.480	3.485		3.485	3.485	3.485		
B	3.990	4.010		3.999	3.999	4.000		
C	3.825	3.845		3.834	3.834	3.835		
D	0.718	0.738		.730	.730	.730		
E	0.090	0.110		.101	.101	.101		
F	3.705	3.725		3.714	3.714	3.715		
G	1.360	1.380		1.370	1.370	1.370		
H	1.250	1.260		1.258	1.258	1.258		
I	6.490	6.510		6.498	6.498	6.498		
J	0.022	0.042		.031	.031	.031		
K	0.240	0.260		.260	.260	.260		
L	0.107	0.127		.114	.115	.114		
M								
N								
O								
P								

Measured by: SA Date: 12/4/24

Audited by: SL Date: 12-04-25

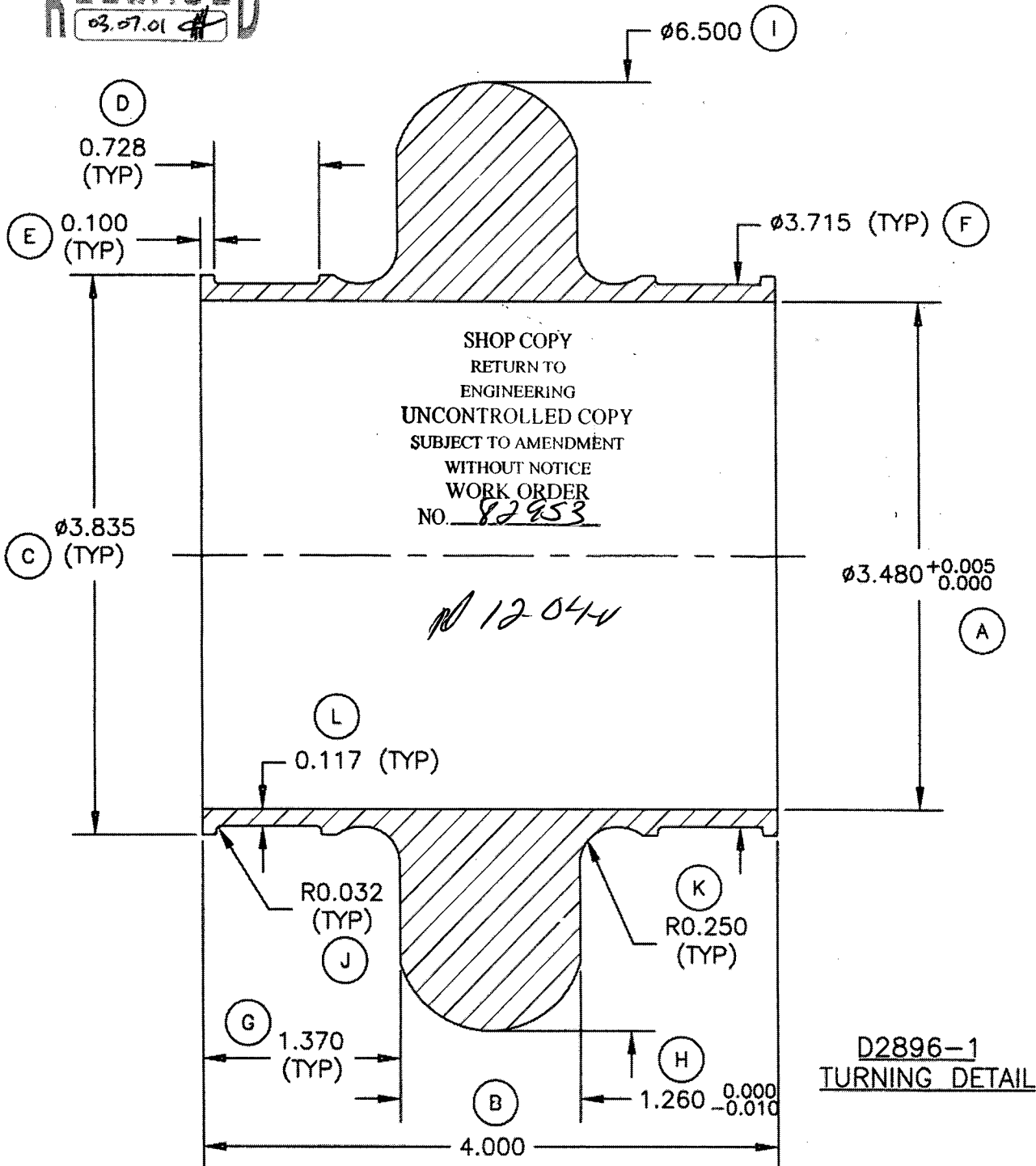
Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SA</u>



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 080	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2896-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



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Dart Aerospace Ltd

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